

Date: Tuesday, 11/29/2005 6:53:30 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER AFT SADDLE
Job Number	: 25044		
Estimate Number	: 11080	Part Number	: D5955
P.O. Number	: N/A	Drawing Number	: D5955 REV A
This Issue	: 11/29/2005 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: N/A Type : MACHINED PARTS	Material	: N/A
Previous Run	: N/A	Due Date	: 11/29/2005 Qty: 4 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Created By Auto Work Order		

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D6101013 Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: B25356

X4

J.G

06/11/10

Tools:

2.0 HAAS3

HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

1325044

2-Machine Keyway PT O

3-Deburr & Tumble

En 06/11/12 X4

Tools:

3.0 QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Tools:

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/11/12

Tools:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05.11.03	2	CHAMFER 0.033 x 45° WAS ADDED AND CALLED (V) SIMILAR TO D2571 SEE ATTACHED	RAH 05.11.03				 06.11.03

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 6:53:31 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 25044

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YLCM 06/11/13 x 4

Tools:

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

Q.M 06/11/15 (4)

Tools:

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 11 15 (4)

Tools:

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

PC 6/11/16 (4)

Tools:

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/11/16 (4)

Tools:

Job Completion



CL 06/11/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Outer Aft Saddle	Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.750	1.748	1.748		
C	5.245	5.255		5.248	5.248	5.249	5.249		
D	6.995	7.005		7.000	7.001	7.002	6.999		
E	5.745	5.755		5.748	5.750	5.750	5.751		
F	4.745	4.755		4.746	4.747	4.747	4.748		
G	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
H	1.522	1.532		1.528	1.528	1.530	1.529		
I	3.048	3.058		3.053	3.054	3.053	3.054		
J	4.575	4.585		4.580	4.579	4.578	4.580		
K	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
L	0.240	0.260		0.255	0.255	0.249	0.254		
M	0.490	0.510		0.503	0.499	0.499	0.502		
N	0.240	0.260		0.254	0.256	0.259	0.255		
O	7.990	8.010		8.006	8.006	8.004	8.005		
P	0.240	0.260		0.257	0.259	0.253	0.256		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.765	0.765	0.765	0.765		
S	0.490	0.510		0.493	0.499	0.494	0.496		
T	1.625	1.645		1.633	1.635	1.632	1.633		
U	2.000	2.020		2.004	2.002	2.004	2.005		
V	0.023	0.043		0.030	0.030	0.030	0.030		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	06/11/12

Audited by:	J.L
Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	



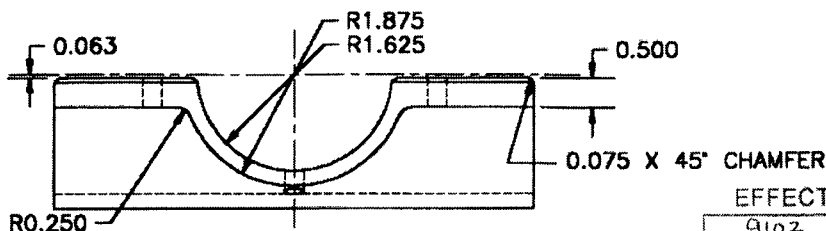
PC 0.0505



DESIGN <i>BW</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D5955	REV. A SHEET 1 OF 1
DATE 97.05.06	TITLE OUTER AFT SADDLE		SCALE

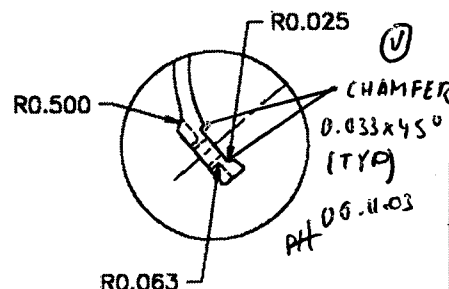
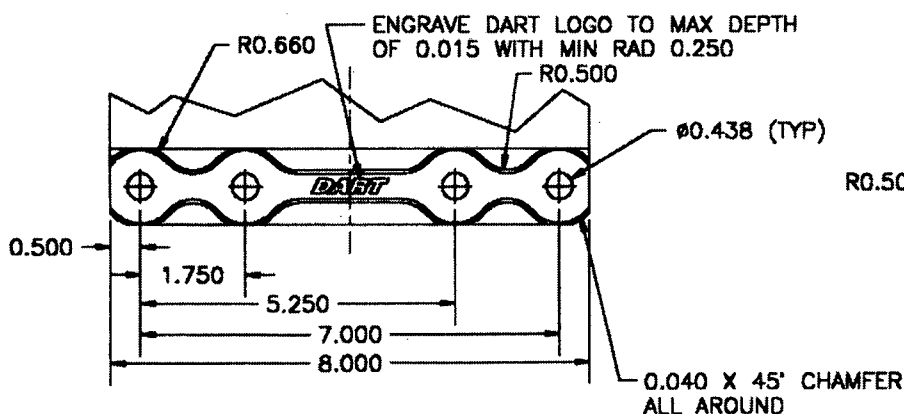
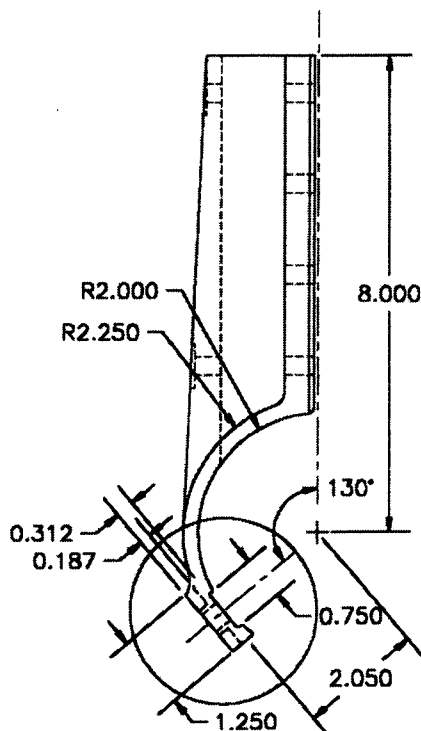
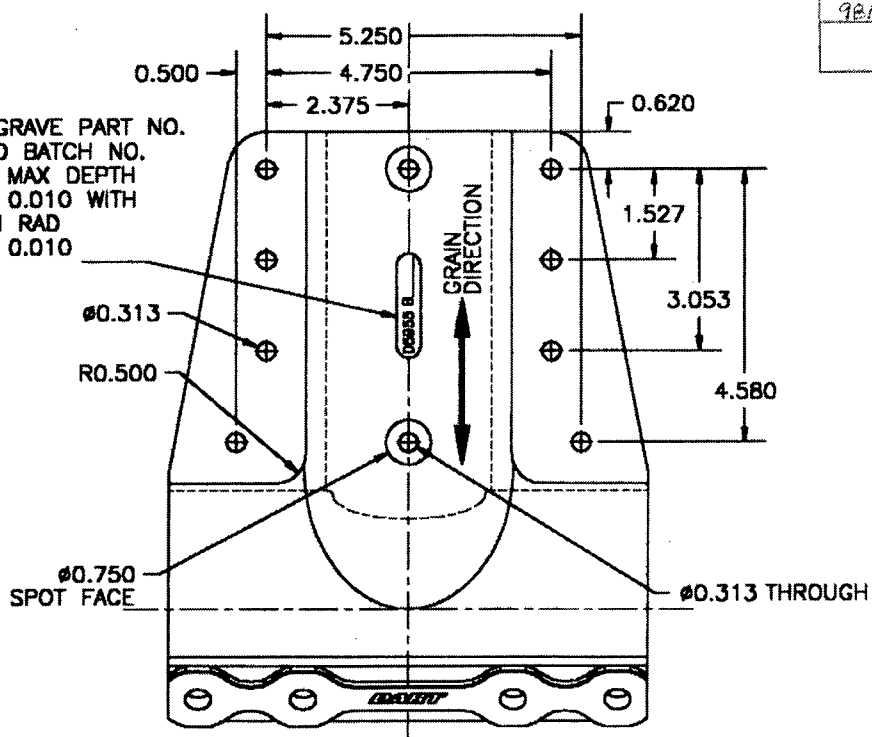
MATERIAL: ~~7075-T651~~ OR 7075-T7351 QQ-A-250/12
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME, PAINT HI GLOSS WHITE (EXCEPT BORES) PER QSI 005 4.2
BREAK ALL SHARP EDGES 0.010 TO 0.020

RELEASED
97/05/14 DS



EFFECTIVE	DEOs
9102 98/05/04 DS	9079 98/06/22 DS

ENGRAVE PART NO.
AND BATCH NO.
TO MAX DEPTH
OF 0.010 WITH
MIN RAD
OF 0.010



Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2006 10:22 AM
To: 'Peter Hum'
Subject: RE: D5951/D5953/D5955/D5957

This change is acceptable to me.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, November 02, 2006 2:33 PM
To: 'David Shepherd'
Subject: D5951/D5953/D5955/D5957

David,

Last year we made a change to the ridges on the 205 saddles (we made a 0.033" X 45 degree chamfer) which I've attached.

Production is making a run of the extended high gear saddles D5951/D5953/D5955/D5957. Can the changes made to the 205 saddles be applied to the x-tended high gear saddles?

The extended high gear goes onto the same D205-634 skidtubes

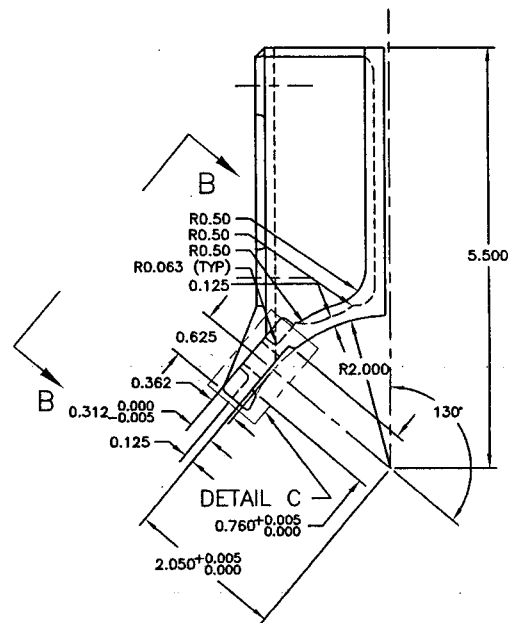
Chris Bell is currently updating the D5951/D5953/D5955/D5957 saddles and if this change is acceptable, we will add it in

Peter

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

03/11/2006



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



ENGRAVE PART AND BATCH NUMBER IN THIS
 AREA TO MAX DEPTH OF 0.010



CHAMFER 0.063" x 45° AROUND THIS SURFACE
 (TYPICAL 2 PLACES)



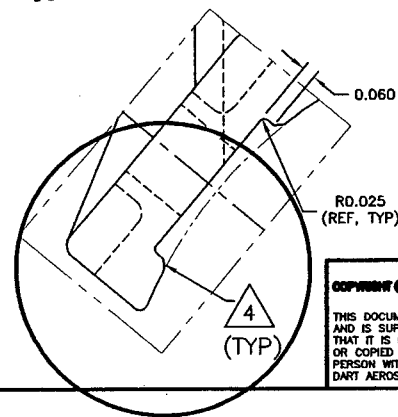
CHAMFER 0.063 x 45° ALL AROUND



CHAMFER 0.033 x 45° (SEE DETAIL C)



REFERENCE ONLY



REFERENCE ONLY

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE INNER AFT SADDLE
DRAWING NO. D2574		REV. E SHEET 1 OF 1 SCALE 2:3

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